



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D412-705-017
Job Sheet 175494



Part No: D412-705-017

Job Qty: 2 ea

Part Name: N1 Gearbox Access Panel



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/5/18

Job Tracking No:

Due Date: 4/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG IIN-D412-705 REV F SHEET 18, D3255 REV B IPP Rev:C Removed Manufacturing 06-08-02 JLM IPP
Rev:D ECN 1052 07-11-06 DD verified by: EG

Ship Via:

DAS
10
9-89

CH5001

DAS
21
9-89

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	4/12/18	4/12/18	0.00	0.00	Start Up Stores/Pkg-2		APR 06 2018
110	Packaging	2 pcs	4/12/18	4/12/18	0.00	0.00	Packaging1-4		APR 06 2018
120	QC	2 pcs	4/12/18	4/12/18	0.00	0.00	QC4		Smb
125	DC	2 pcs	4/12/18	4/12/18	0.00	0.00	DC		
130	Packaging	2 pcs	4/12/18	4/12/18	0.00	0.00	Packaging3-2		Smb
140	QC21-FG	2 Ea	4/12/18	4/12/18	0.00	0.00	QC21		APR 09 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C3A	Bolt	60 Ea (30 ea)	90-Start up Operation	50A392
D3255-041	Access Panel Assembly LH	2 Ea (1 ea)	90-Start up Operation	500583
D3255-042	Access Panel Assembly	2 Ea (1 ea)	90-Start up Operation	5005215
MS20427M3-3	Rivet	72 Ea (36 ea)	90-Start up Operation	500523x1 fm 136741-4
MS21060-L3K	Nut Plate 502471X 8	36 Ea (18 ea)	90-Start up Operation	500523x1 fm 1332970 x27
MS9321-09	Washer	60 Ea (30 ea)	90-Start up Operation	fm 136740-15

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3C3A	60	488	0
	D3255-041	2	2	0
	D3255-042	2	2	0
	MS20427M3-3	72	1,029	0
	MS21060-L3K	36	92	0
	MS9321-09	60	170	0

Part Specifications

2309

Specifications could not be found.

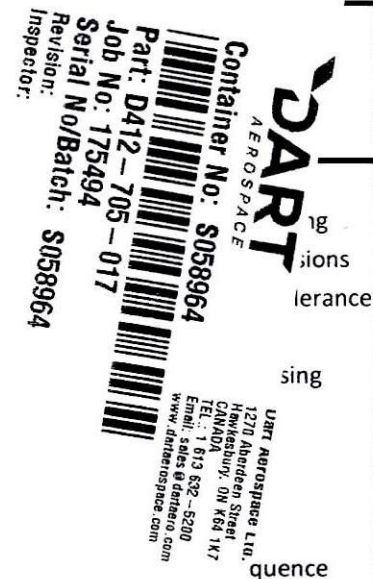
DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Lo ☐ Folio/Prc ☐ Grain ☐ Weld ☐ Wrong ☐ Out of ☐ Off-se ☐ Misla ☐ Fit/F ☐ Mis: ☐	Date: 04/06/18
		OTHER : _____			





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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
002309	S058961	AN3C3A	Bolt	s019392	ST350	60
002309	S005183	D3255-041	Access Panel Assembly LH	S008146	ST489	2
002309	S005215	D3255-042	Access Panel Assembly	F154908	ST489	2
002309	S058960	MS20427M3-3	Rivet	fm136741-4	ST311	72
002309	FM135297-0	MS21060-L3K	Nut Plate		GA012	27
002309	S000563	MS21060-L3K	Nut Plate		ST300	1
002309	S058953	MS21060-L3K	Nut Plate	s024471	ST300	8
002309	S058936	MS9321-09	Washer	fm136740-15	ST267	60

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

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5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-705-011	TWIN PAK E-Z ACCESS KIT
1	X						D412-705-013	INTAKE PLENUM ACCESS PANEL KIT
1		X					D412-705-015	DRIVESHAFT TUNNEL MODIFICATION KIT
1			X				D412-705-017	N1 GEARBOX ACCESS PANEL KIT
1				X			D412-705-019	C-BOX OIL COOLER LINE SUPPORT ACCESS KIT
1					X		D412-705-021	OIL PRESSURE TRANSMITTER ACCESS KIT
1						X	D412-705-023	OIL COOLER SUPPORT REMOVABLE LOWER PANEL KIT
	1						D3245-041	ACCESS PANEL ASSEMBLY, LH
	1						D3245-042	ACCESS PANEL ASSEMBLY, RH
	2						D3245-043	DOOR ASSEMBLY
	2						D3245-9	GASKET
	2						D3245-11	GASKET
	2						D3245-13	GASKET
			1				D3255-041	ACCESS PANEL ASSEMBLY, LH
			1				D3255-042	ACCESS PANEL ASSEMBLY, RH
		1					D3256-1	ACCESS PANEL
		1					D3256-3	GASKET
							D3259-041	ACCESS PANEL ASSEMBLY, LH
							D3259-042	ACCESS PANEL ASSEMBLY, RH
					1		D3307-041	ACCESS PANEL ASSEMBLY
						30	AN3-3A	BOLT
		22	30		6		AN3C3A	BOLT
		3					AN3C4A	BOLT
						30	AN960JD10	WASHER
16	44	36			12		MS20427M3-3	* RIVET
						4	MS21051-L3K	NUT PLATE
8	22	18			6		MS21060-L3K	NUT PLATE
						18	MS21069-L3K	NUT PLATE
		25	30		6		MS9321-09	WASHER

* Acceptable to substitute for MS20615M3-3 rivets. At installation, it is acceptable to use longer rivets if required.